

Date: 6/23/2006 7:33AM
User: Kim Johnston

PROCESS SHEET

| | | | |
|--------------|---------------------------------------|--------------|--------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : WEB |
| Job No. | : 27665 | Part No. | : D2739 |
| Estimate No. | : 10498 | Drawing No. | : D2739 REV C |
| P.O. No. | : NIA SO No. NIA | Drawing Rev. | : C |
| First Issue | : NIA | Project No. | : N/A |
| Prsht Rev. | : NC Type: LANDING GEAR | Material | : NIA |
| This Issue | : 6/23/2006 | Due Date | : 7/10/2006 QTY: 6 |
| Prev. Run | : 27503 | | |

Written by:

Checked & Approved by:

Comment :

Est Rev: C 02.11.28 Reformat KJ
Est Rev: D 06-03-21 As Per Rev C JLM

Job Number:



| Seq. No. | Machine or Operation | Description |
|----------|----------------------|--|
| 1.0 | D26005108 | Extrusion 'I Beam' thin |
| | | |
| | Comment: | Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Extrusion 'I Beam' thin Pick: Qty Part Number Description Batch 1 D2600-5 Web B2440 Pm 06-07-10 (6) |
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
| | | |
| | Comment: | LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2739. Pm 06-07-10 (6) 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 Pm 06-07-10 (6) 3-Use uni-bit to open holes to finish size as per Dwg D2739. Pm 06-07-10 (6) 4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. Pm 06-07-10 (6) 5-Deburr Pm 06-07-10 (6) |
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| | | |
| | Comment: | INSPECT WORK TO CURRENT STEP BE 06-07-10 (6) |
| 4.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
| | | |
| | Comment: | HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 Pm 06-07-10 (1) (6) |
| 5.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
| | | |
| | Comment: | INSPECT POWDER COAT/CHEMICAL CONVERSION Pm 06-07-10 (5) BE 06-07-10 (5) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Number:



| Seq. No. | Machine or Operation | Description |
|----------|--|-----------------------|
| 6.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | | |
| | <p>Comment: PACKAGING RESOURCE #1 Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web. Identify and Stock Location: <u>LG</u></p> <p>pm' 06-07-10 (6)</p> | |
| 7.0 | DC | DOCUMENT CONTROL |
| | | |
| | <p>Comment: DOCUMENT CONTROL Inspection Level 21</p> <p>Stock 7/11 (6) 7/11 06.07.11</p> | |

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

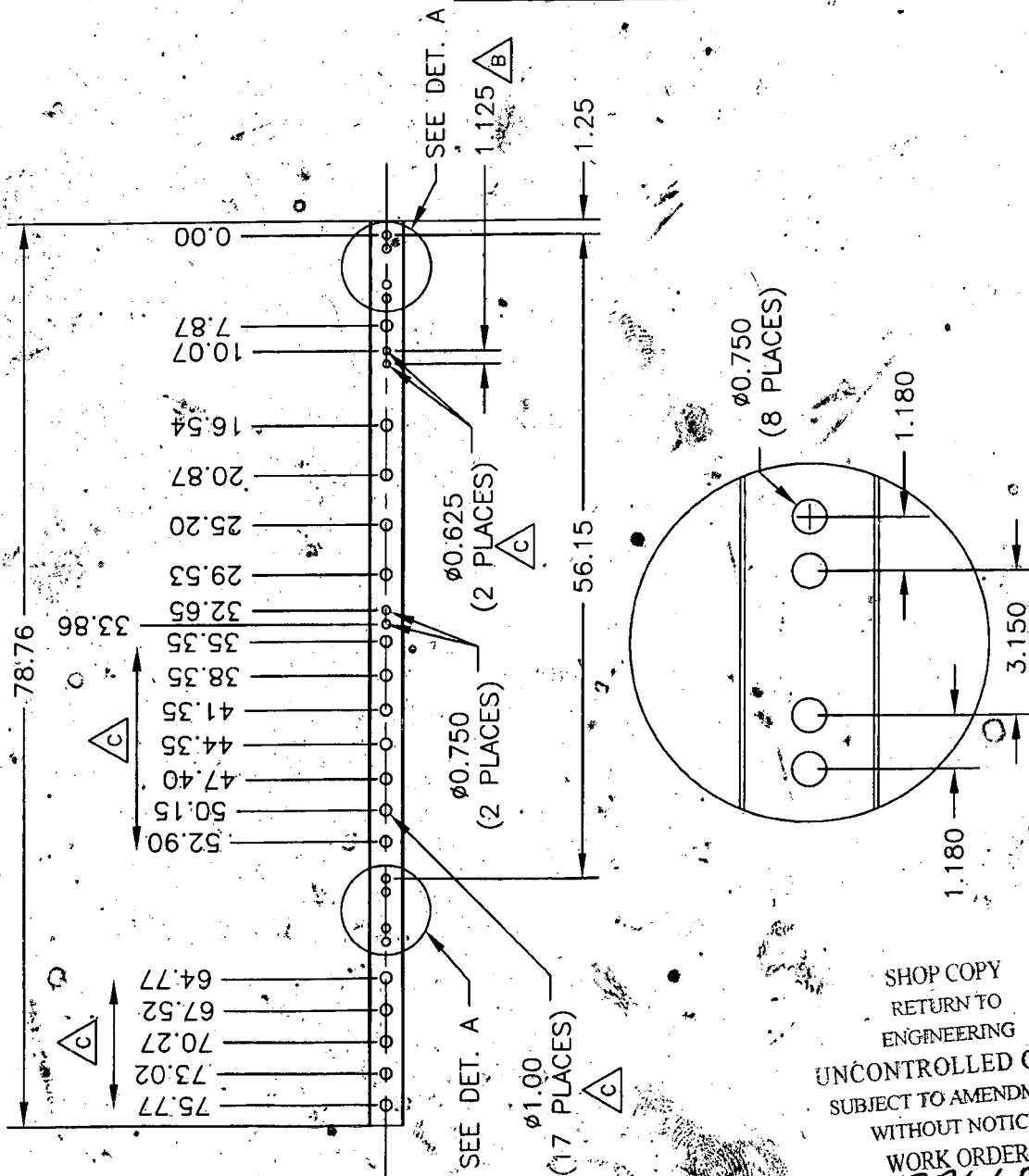
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART**RELEASED**
06-02-97

| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN RH | DRAWN BY RH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2739 | REV. C SHEET 1 OF 1 |
| DATE 06.01.05 | TITLE WEB | | SCALE 1:15 |
| A | 98.04.16 | NEW ISSUE | |
| B | 98.11.18 | CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS | |
| C | 06.01.05 | ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS | |



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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27665

DETAIL A

D2739 WEB
1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
ACID ETCH, ALODINE PER DART QSI 005 4.1
2) FINISH: ALL DIMENSIONS ARE IN INCHES
3) TOLERANCES ARE PER DART QSI 018, UNLESS OTHERWISE NOTED

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